

Work Order ID ~~76950~~ **ASAP**

November-24-11 11:21:57 AM

76950

U/R

Page 1

Item ID: D3564-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 24/11/2011 Start Qty: 16.00

16

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/11/24 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3564

Rev D U/R OK 11.11.28

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D U/R Prog
Rev: D U/R 2-Deburr if necessary

131-12-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

131-12-1

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

11.12.01 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76950

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Page 2

Item ID: D3564-9 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Wearshoe
 Start Date: 24/11/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157	0.00 0.00				(16)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429	0.00 0.00							
150 *150* Large Fab Large Fab	Large Fab Memo Qty Description Batch A/R 2059B Hardcoat 120645 Weld hardcoat as per Dwg D3564	0.00 0.00							

SB

11/12/07

8-11/12/07

(16) ME/MAL 2012-02-23

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC10- Inspect visual per QSI004- ground welds	0.00							
160									
QC	Memo	0.00				16x	Ø		
Quality Control									

170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00				W	12	02	24 (16)
Quality Control									

180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
180									
Powdercoat	Memo	0.00				16x	Ø	M-12/22/27	
Powder Coating									

START TIME: 10:00 OVEN TEMPERATURE: 10:30
 FINISH TIME: 320012

W118484

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							16x d JH 12/02/27 COUNTED x MEASUREMENT
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>FPI</u> Memo	0.00 0.00							16x & (DP) M 12/02/27
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MJ 12/02/28 R 12-02-27 (16)

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Picklist Print

November-24-11 11:22:01 AM

Page 1

Work Order ID: 76950

76950

Parent Item: D3564-9

D3564-9

Parent Item Name: Wearshoe

Start Date: 24/11/2011

Required Date: 01/12/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

303.6000

1.41

23.74737

M304S16GA

**

18112-1

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

303.6

119346

26.6

119653

277

119653

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DART AEROSPACE LTD		Work Order:	76950
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	2		V B02	
2.432	+/-0.010	2.440	2		V	
2.50	+/-0.030	2.50	2		V	
6.000	+/-0.010	6.00	2		T B01	
12.104	+/-0.010	12.104	2		T	
18.000	+/-0.010	18.000	2		T	
18.000	+/-0.010	18.000	2		T	
18.00	+/-0.030	18.00	2		T	
9.00	+/-0.030	9.00	2		T	
11.50	+/-0.030	11.50	2		T	
0.300 x 0.300	+/-0.010	300x300	2		V	
Ø0.188	+0.005/-0.001	Ø0.189	2		V	
R0.375	+/-0.010	0.375	2		R.G.	
0.063	+/-0.010	0.060	2		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-12-1	Date: 11-12-01	Date:	N/A

Rev	Date	Change	Revised by:	Approved
A	08.01.16	New Issue	KJ/EC/DD [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

SHO/COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76950 M.C.J.

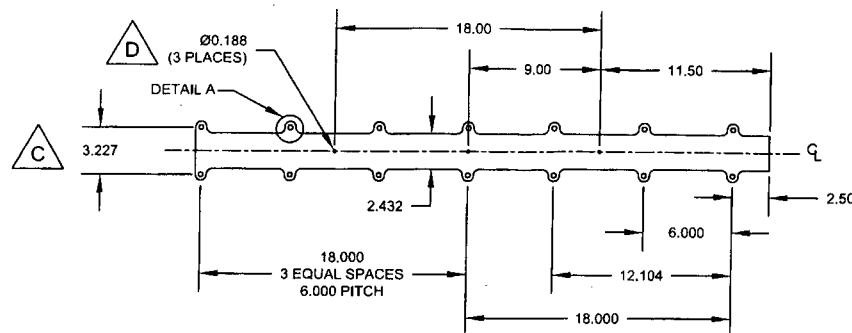
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11/11/24

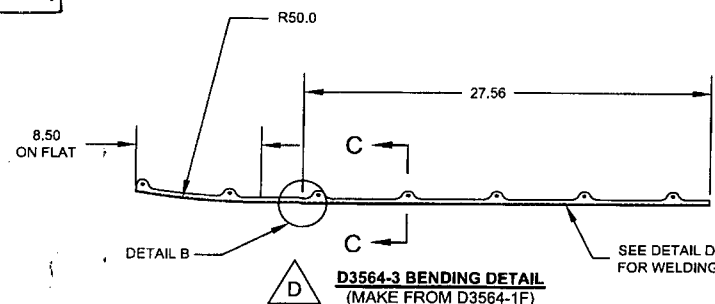
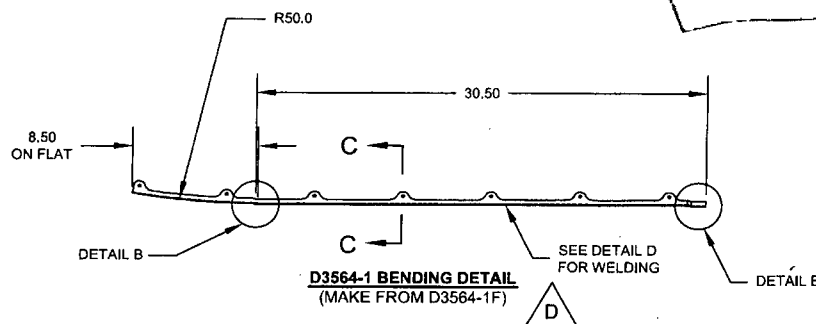
07.09.04

UNDER REVIEW

Final change



D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT Q

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
REV. D
SHEET 1 OF 3
TITLE WEARSHOE
SCALE 1:8

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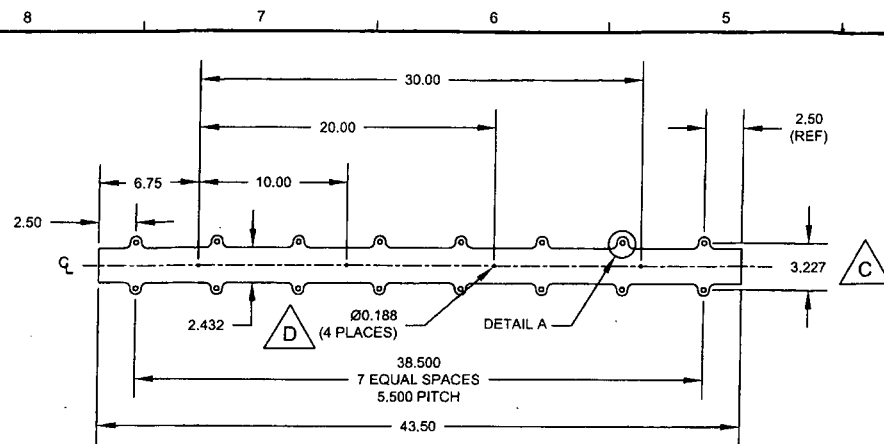
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

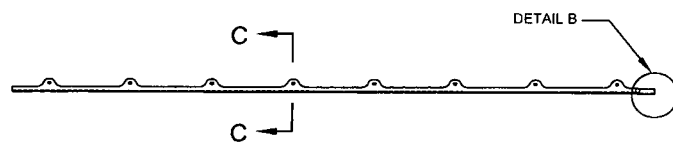
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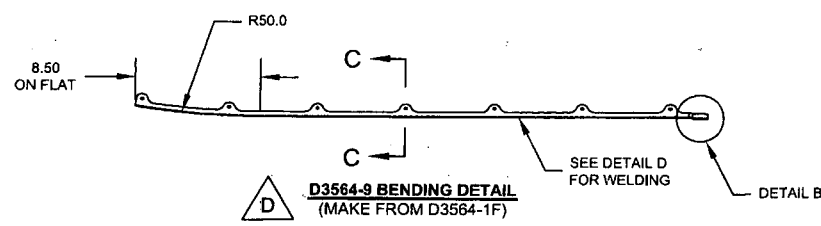
76950



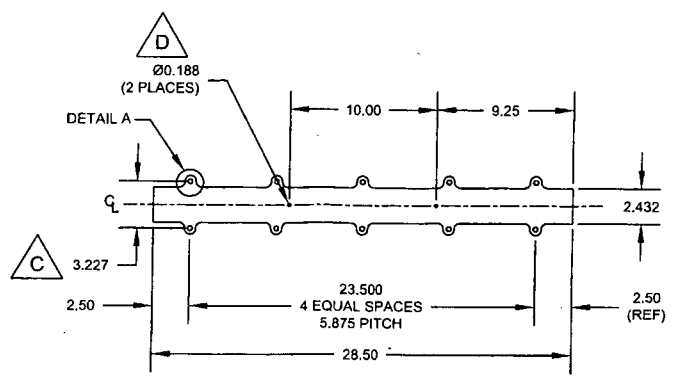
D3564-5F FLAT PATTERN



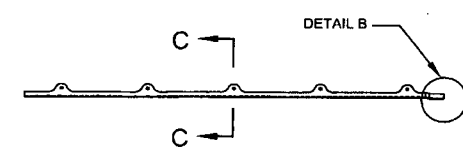
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



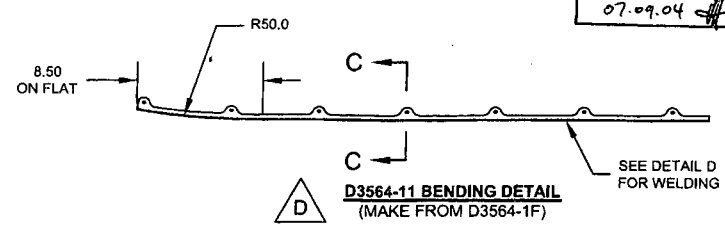
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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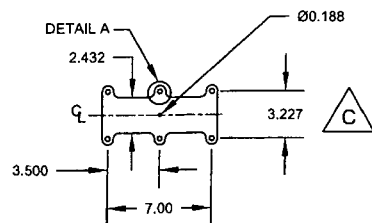
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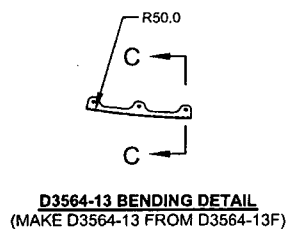
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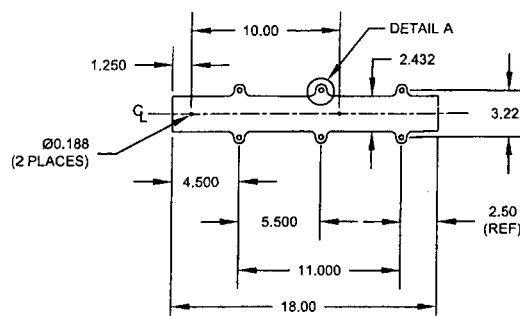
76950



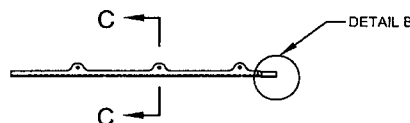
D3564-13F FLAT PATTERN



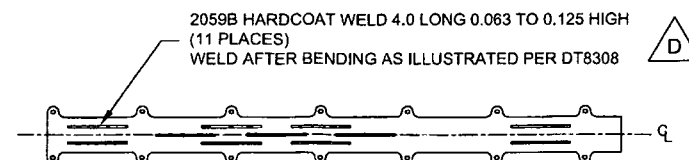
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



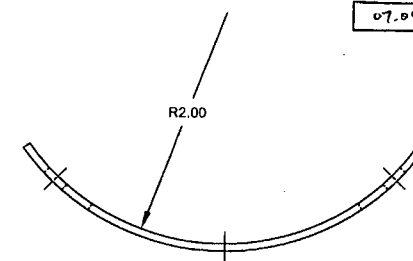
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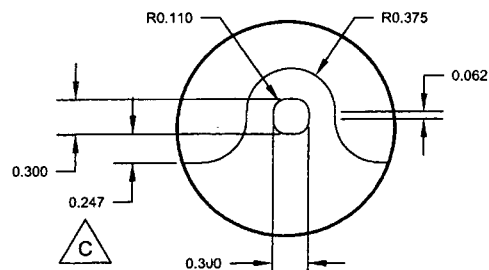
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



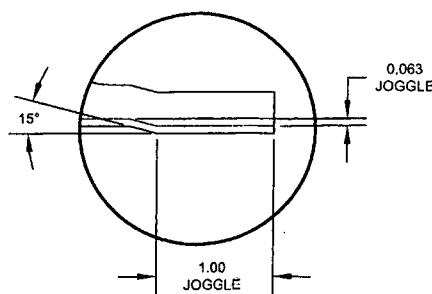
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

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APPROVED	PH	TITLE	SCALE
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